

Work Order ID 56531

March 1, 2010 9:31:13 AM



Page 1

Item ID: D3538-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 3/01/10 Start Qty: 12.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 12.00



Customer:

Reference:

[Handwritten signature]

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3538

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 1.500" long

DJP
10/03/03

12 *0*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA651 and Dwg D3538U2-Deburr

MMJ=
10/03/04

12 *0*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

MMJ=
10/03/04

12 *0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56531



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March 1, 2010 9:31:14 AM

Item ID: D3538-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 3/01/10 Start Qty: 12.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:00AM FINISH TIME: 10:30AM OVEN TEMPERATURE: 320°F

SA 10/04/04

12

W 10/03/05

X12

W 10/03/10 X13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56531

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Item ID:	D3538-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Hinge Bracket					
Start Date:	3/01/10	Start Qty:	12.00			
Required Date:	3/08/10	Req'd Qty:	12.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00	BR 103-10			(12)	2		
QC Quality Control	Memo	0.00							
170 	Identify as per dwg & Stock Location: 69	0.00							
Packaging Packaging	Memo	0.00							
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/3/10 12

10/3/10
MF 10-3-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 1, 2010 9:31:13 AM

Page 1

Work Order ID: 56531



Parent Item: D3538-1



Parent Item Name: Hinge Bracket

Start Date: 3/01/10

Required Date: 3/08/10

Comments: IPP Rev:A New Issue 06-10.03 EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	48.8800	2.4000			



6061-T6 Bar 1.25 x 1.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

48.88

106259

14

109058

21.43

110001

13.45

2.4 DTP 10/03/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Hinge Bracket		Part Number:	D3538-1
Inspection Dwg: D3538 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

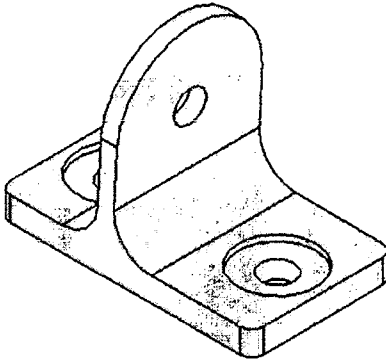
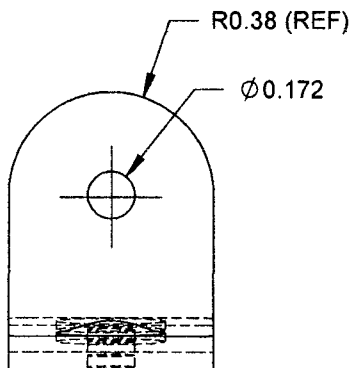
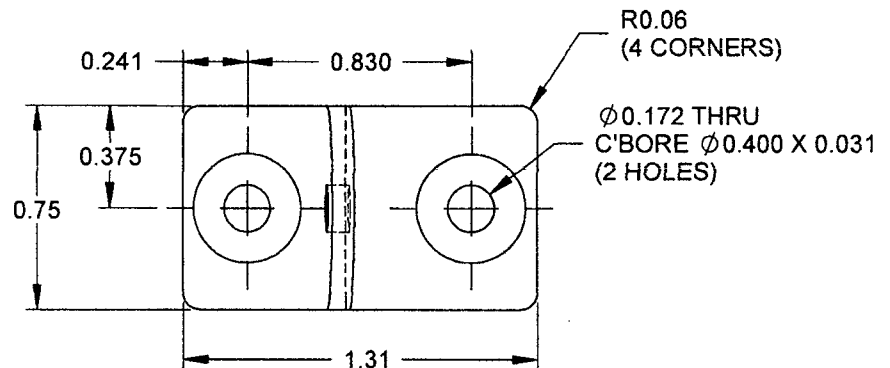
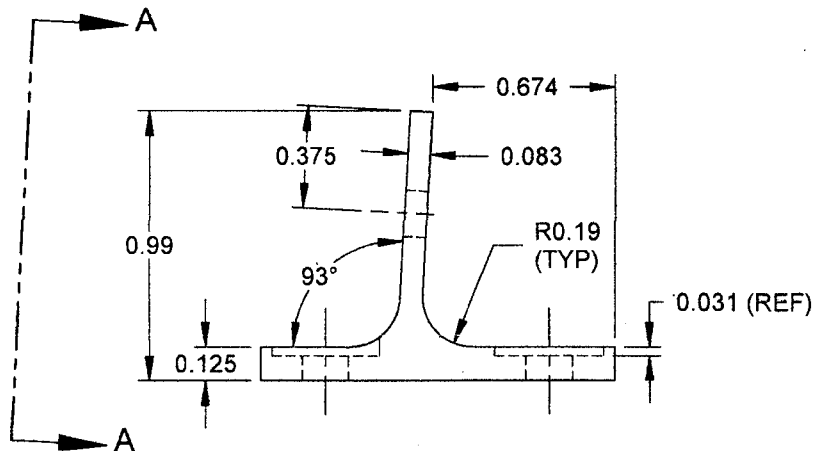
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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0.375	+/-0.010	.375	✓			
0.241	+/-0.010	.244	✓			
0.830	+/-0.010	.828	✓			
Ø0.172	+0.005/-0.001	Ø.175	✓			
Ø0.400	+0.006/-0.001	Ø.400	✓			
0.031	+/-0.010	.029	✓			
1.31	+/-0.030	1.31	✓			
0.375	+/-0.010	.374	✓			
0.99	+/-0.030	.992	✓			
0.125	+/-0.010	.126	✓			
R0.19	+/-0.030	R.19	✓			
0.083	+/-0.010	.084	✓			
93°	+/-0.5°	.93°	✓			
0.674	+/-0.010	.674	✓			
R0.38	+/-0.030	R.38	✓			
Ø0.172	+0.005/-0.001	Ø.175	✓			

Measured by: <i>MW</i>	Audited by: <i>SA</i>	Prototype Approval:	N/A
Date: 10/03/04	Date: 10/05/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. D3538	REV. A SHEET 1 OF 2
DATE 06.10.13	TITLE HINGE BRACKET		SCALE 1:1
REV A	DATE 06.10.13	DESCRIPTION NEW ISSUE	

**RELEASED**
(06.10.13) #**AUXILIARY VIEW A****D3538-1 HINGE BRACKET****NOTES:**

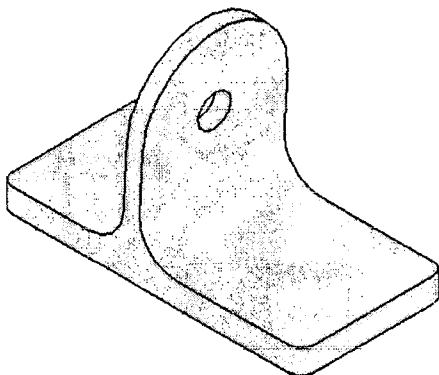
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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

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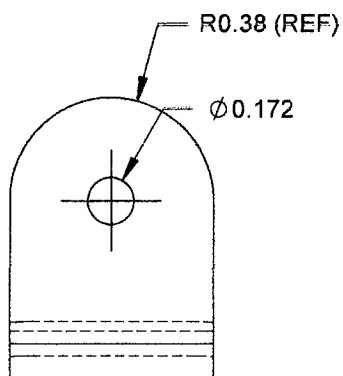
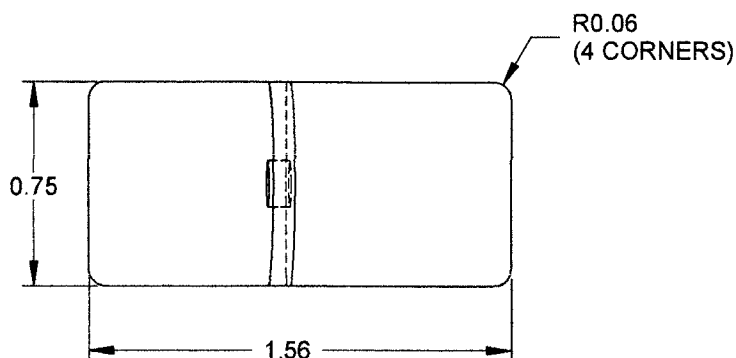
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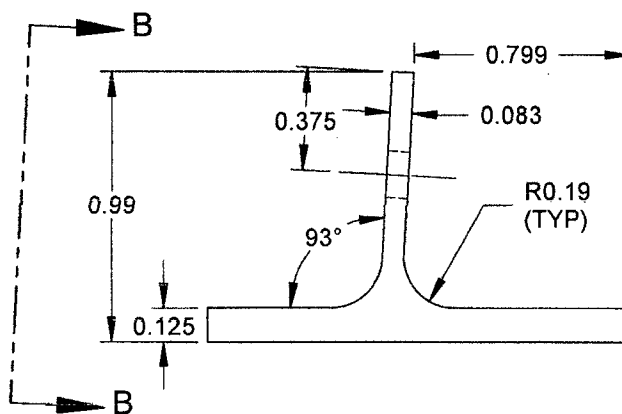
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3538	REV. A SHEET 2 OF 2
DATE 06.10.13		TITLE HINGE BRACKET	SCALE 1:1



RELEASED
06.10.13



AUXILIARY VIEW B



D3538-3 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

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